

Date: Wednesday, 4/4/2007 9:03:40 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GUSSET
Job Number	: 31609C		
Estimate Number	: 10843		
P.O. Number	: N/A	Part Number	: D22495
This Issue	: 4/4/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2249 REV. E
First Issue	: N/A	Project Number	: N/A
Previous Run	: 31485C	Drawing Revision	: E
		Material	: N/A
		Due Date	: 4/11/2007
Written By	: <u>AP 07.04.04</u>	Qty:	20 Um: Each
Checked & Approved By	: <u>AP 07.04.04</u>		
Comment	: Est: D 06.02.04 Added Step 9 KJ/RF		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.0243 sf(s)/Unit Total : 0.4860 sf(s)  
 304/316 .063 Sheet  
 Material: AISI 304/316 SS 0.063" thick  
 (M304S16GA) Batch: M101873 ✓ ml 07/04/24

2.0	SHEAR	SHEAR
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Comment: SHEAR  
 Cut blank: 1.000" x 1.600" ml 07/04/24

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Deburr any rough edges ml 07/04/24 X20

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP SB 07/04/25 (20)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
 Identify and Stock  
 Location: ST21 7/4/25 50 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/27  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/4/2007 9:03:40 AM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUSSET

Job Number: 31609C

Part Number: D22495

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

207104/27

Job Completion



u 07-04-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

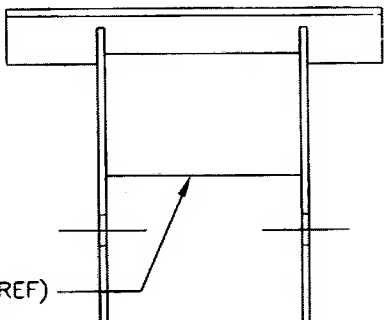
**NOTE:** Date & initial all entries

**DART**



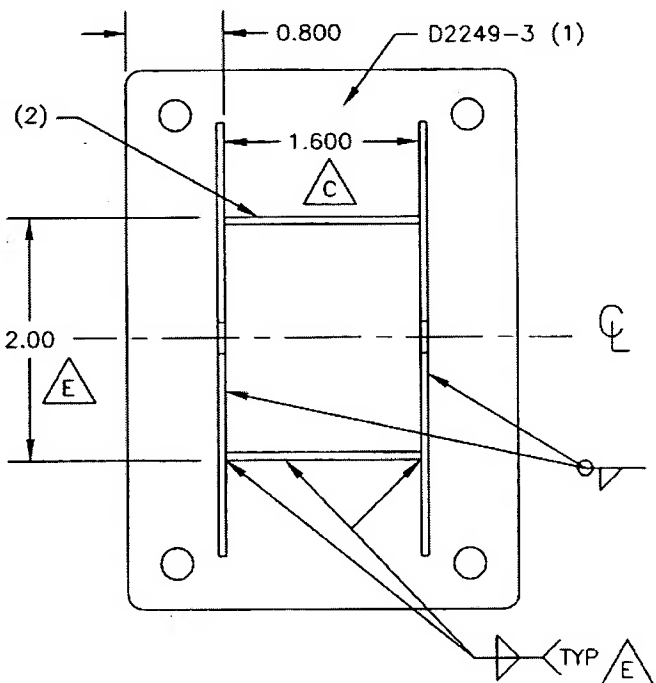
**RELEASED**  
99.10.12 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
AE	RF	DRAWING NO.	REV. E
CHEKED KE	APPROVED RF	D2249	SHEET 1 OF 4
DATE 99.09.20	TITLE FITTING	SCALE NTS	
A	94.06.20	NEW ISSUE	
B	95.11.30	DIMENSION CHANGE	
C	95.12.14	DIMENSION CHANGE	
D	98.04.30	Ø0.261 WAS Ø0.257 (TSR A179) REMOVED DUPLICATE DIMENSIONS	
E	99.09.20	ADDED GUSSET	



E

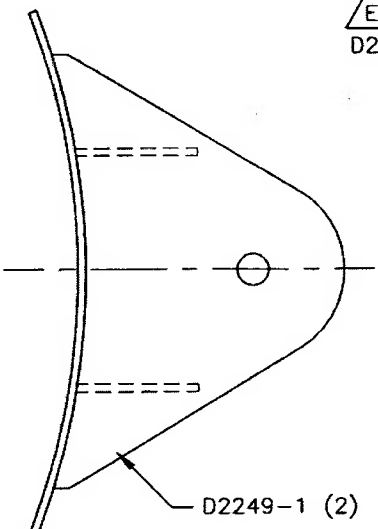
D2249-5 (REF)



WELD  
USING TOOL  
DT8209

D2249-041 ASSEMBLY

MATERIAL: AISI 304/316 SS, 0.063 THICK  
WELD PER DART QSI 004  
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
ALL DIMENSIONS ARE IN INCHES  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED



D2249-1 (2)

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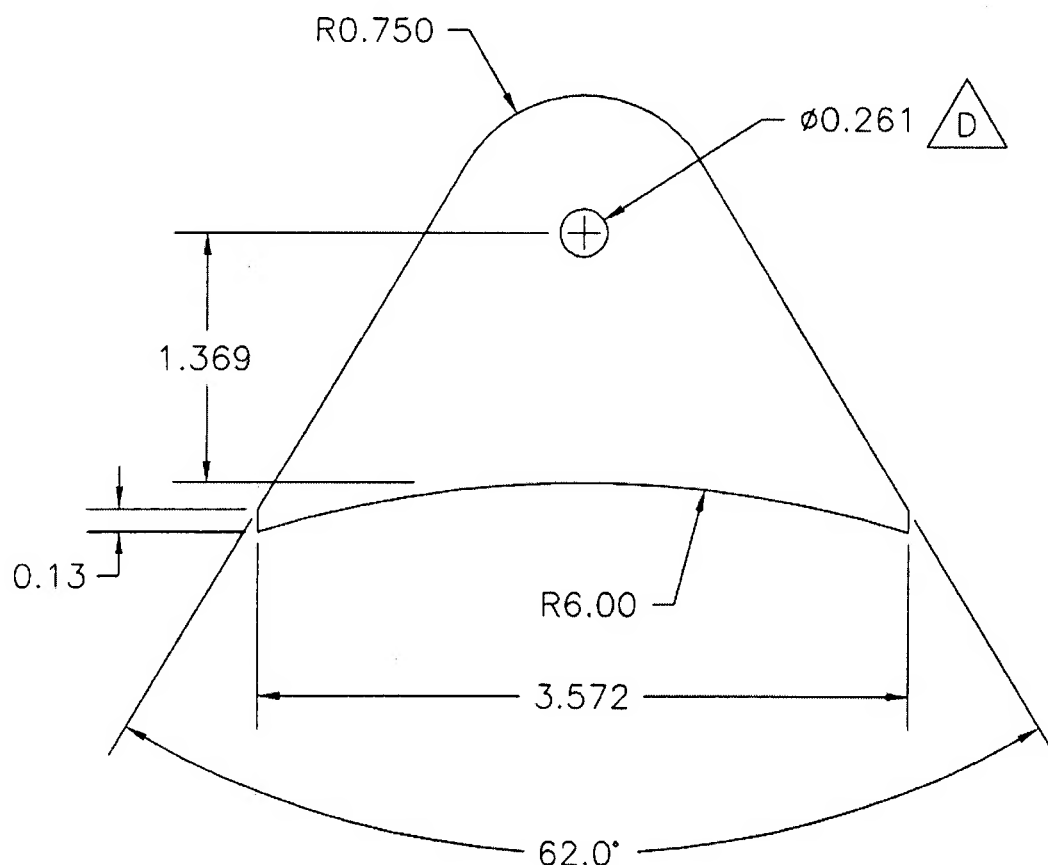
ATTACH ORDER

NO. 31609C



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2249	REV. E SHEET 2 OF 4
DATE 99.09.20	TITLE FITTING		SCALE 1:1

RELEASED  
99.10.12 *KE*



D2249-1 LUG

MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

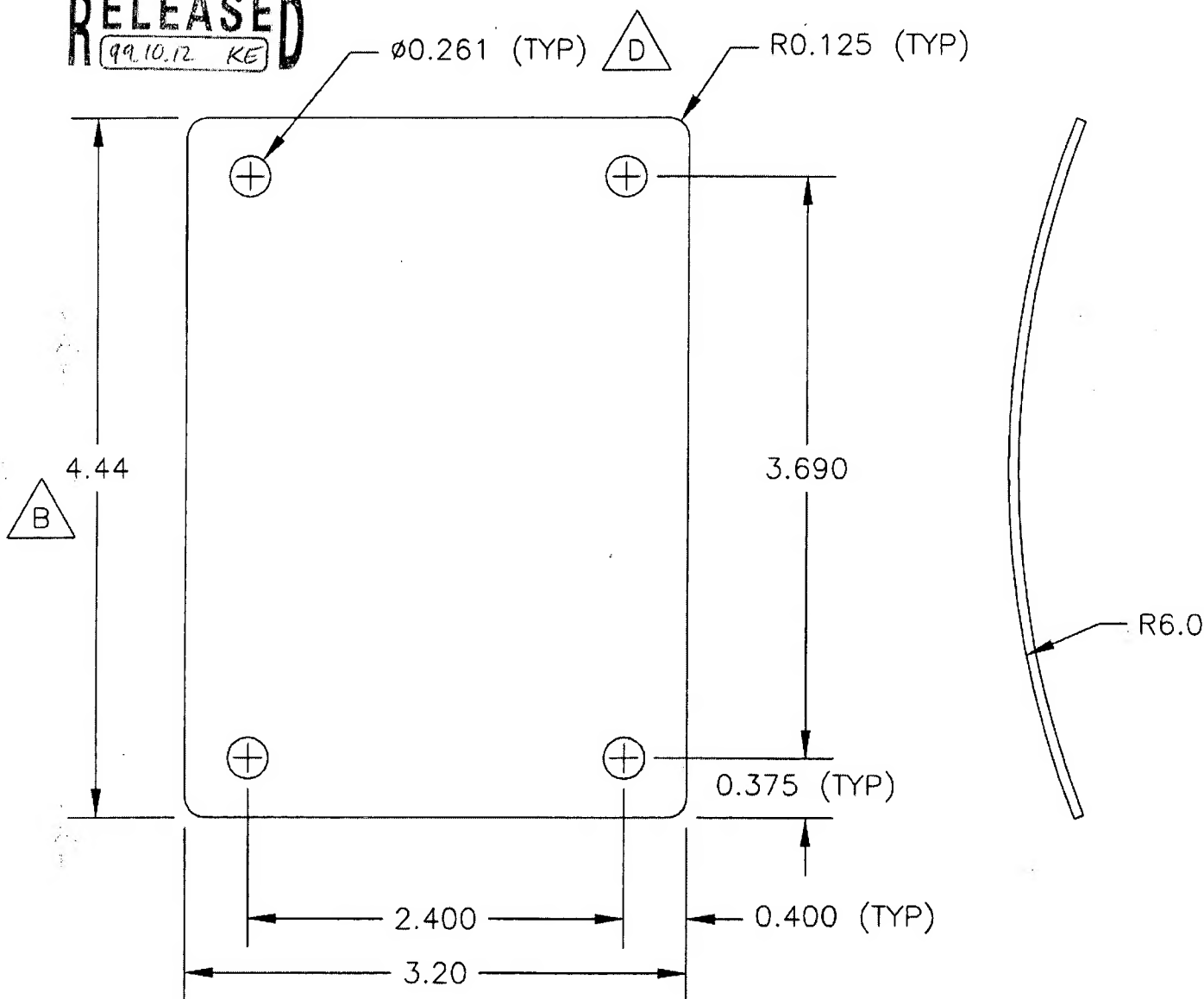
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DATE 99.09.20		TITLE FITTING	SCALE 1:1

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99.10.12 KE



FLAT PATTERN

BEND DETAIL

D2249-3 BASE PLATE

MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

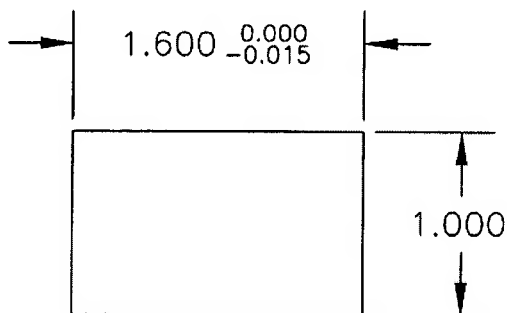
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NO. 31609c



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CHECKED <i>KE</i>	APPROVED <i>RF</i>	DRAWING NO. D2249	REV. E SHEET 4 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

RELEASED  
19.10.12 *KE*



D2249-5 GUSSET

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WITHOUT NOTICE  
WORK ORDER  
NO. 31609C

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ALL DIMENSIONS ARE IN INCHES  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED